

Date: Thursday, 3/2/2006 3:07:31 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ANGLE				
Job Number	: 26028			<u>L-2 : 2628 w/b</u>				
Estimate Number	: 10196							
P.O. Number	: N/A			Part Number	: D21751			
This Issue	: 3/2/2006		S.O. No.	: N/A				
Prsht Rev.	: NC			Drawing Number	: D2175 REV. D			
First Issue	: N/A		Type	: MACHINED PARTS				
Previous Run	: N/A		Material	: N/A				
Written By	: <u>SEE COMMENT BELOW</u>			Due Date	: 3/25/2006			
Checked & Approved By	: <u>KJ 06/03/02</u>			Qty:	40			
Comment	: Est E 04.06.09 Reformat KJ/RF			Um:	Each			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 0.4958 sf(s)/Unit Total : 19.8324 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)	<u>ML 06/03/18</u> 40
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blank: 12.75" x 2.95" Grain along 2.95"	<u>ML 06/03/18</u> 40
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA083 and Dwg D2175 Stack of 10 Identify as D2175-1	<u>ML 06/03/18</u> 40
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>ML 06/03/18</u> 40
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>ML 06/03/18</u> 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/27	7	2 piece was scrap bend or wrong way	BS 06/03/27	Scrap destroyed	SB 06/03/27	2	BS 06/03/27	06/03/27

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

5AD

06-03-20

39
36

39

7.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

JB 06/03/27

37
38

38

8.0 QC5

INSPECT WORK TO CURRENT STEP



J 06-03-28

38

Comment: INSPECT WORK TO CURRENT STEP

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-03-31

38

38

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

DL 06/04/01

38

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Qty 1



D2175-1 19

Comment: PACKAGING RESOURCE #1

D2175-2 19

CD 06/04/03

38

Identify and Stock

Location: ST220

12.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/04

u 06/04/04

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26028
Description: Angle	Part Number:	D2175-1/-2
Inspection Dwg: D2175	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

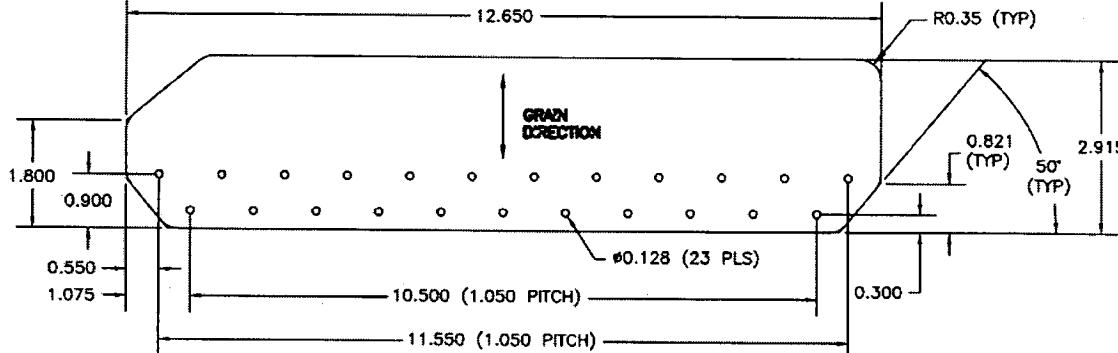
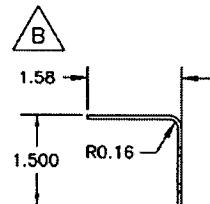
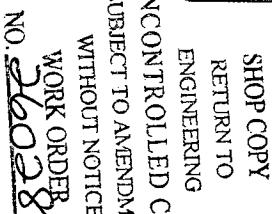
X First Article Prototype

Measured by:	<u>gml</u>	Audited by:	<u>MS</u>	Prototype Approval:	N/A
Date:	06/03/18	Date:	06/03/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	

DARTDRAFT COPY
DRAFTDESIGN
FDRAWN BY
FDART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADAREV. D
SHEET 1 OF 1
1:3**RELEASED**

DESIGN	DRAWN BY	DART AEROSPACE LTD
F	F	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>H</i>	<i>H</i>	D2175
DATE 04.06.03		TITLE ANGLE
		SCALE 1:3
A	95.10.25	NEW ISSUE
B	96.01.18	CHANGED DIMENSION
C	00.09.11	UPDATE FINISH SPEC
D	04.06.03	RE-DESIGN

**D2175 FLAT PATTERN****D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 26028NOTES:
1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSIONS ARE IN INCHES

